

SHIP 08/01/10

Work Order ID 55138

January 7, 2010 8:20:20 AM



Item ID: D3805-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

Rev A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- on D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: *M113521*

2-weld D3806-3 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH#: *M102421*

3-Transfer drill holes in bar

EL 10-1-7 *(X2)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.0.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55138

January 7, 2010 8:20:20 AM



Page 2

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Cust Item ID:

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8106108



130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M. 112588.

Memo

0.00

Powder Coating

START TIME: 9:00
OVEN TEMPERATURE: 320°
FINISH TIME: 9:30

Bl 10-01-8



140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

U 10-01-8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55138

January 7, 2010 8:20:21 AM



Page 3

Item ID: D3805-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: M113174

EP 10/01/08 (2)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27S 10/01/08

(+2)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-1-08

(20)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 55138

January 7, 2010 8:20:21 AM



Page 4

Item ID: D3805-043

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Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/11

MF

10-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2010 8:20:19 AM

Page 1

Work Order ID: 55138

Parent Item: D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear


Start Date: 1/07/10

Required Date: 1/08/10

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3805-3  Plate		Manufactured	No			100	Each	7.0000	2.0000			

EL 10-1-7

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

46930

1

52853

6

D3806-3

Manufactured

No

100

Each

6.0000

2.0000



Bar

7

EL 10-1-7

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

6

52852

6

D3807-3

Manufactured

No

150

Each

7.0000

2.0000



Gasket

2

Ep 10/01/08

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

52836

7

2

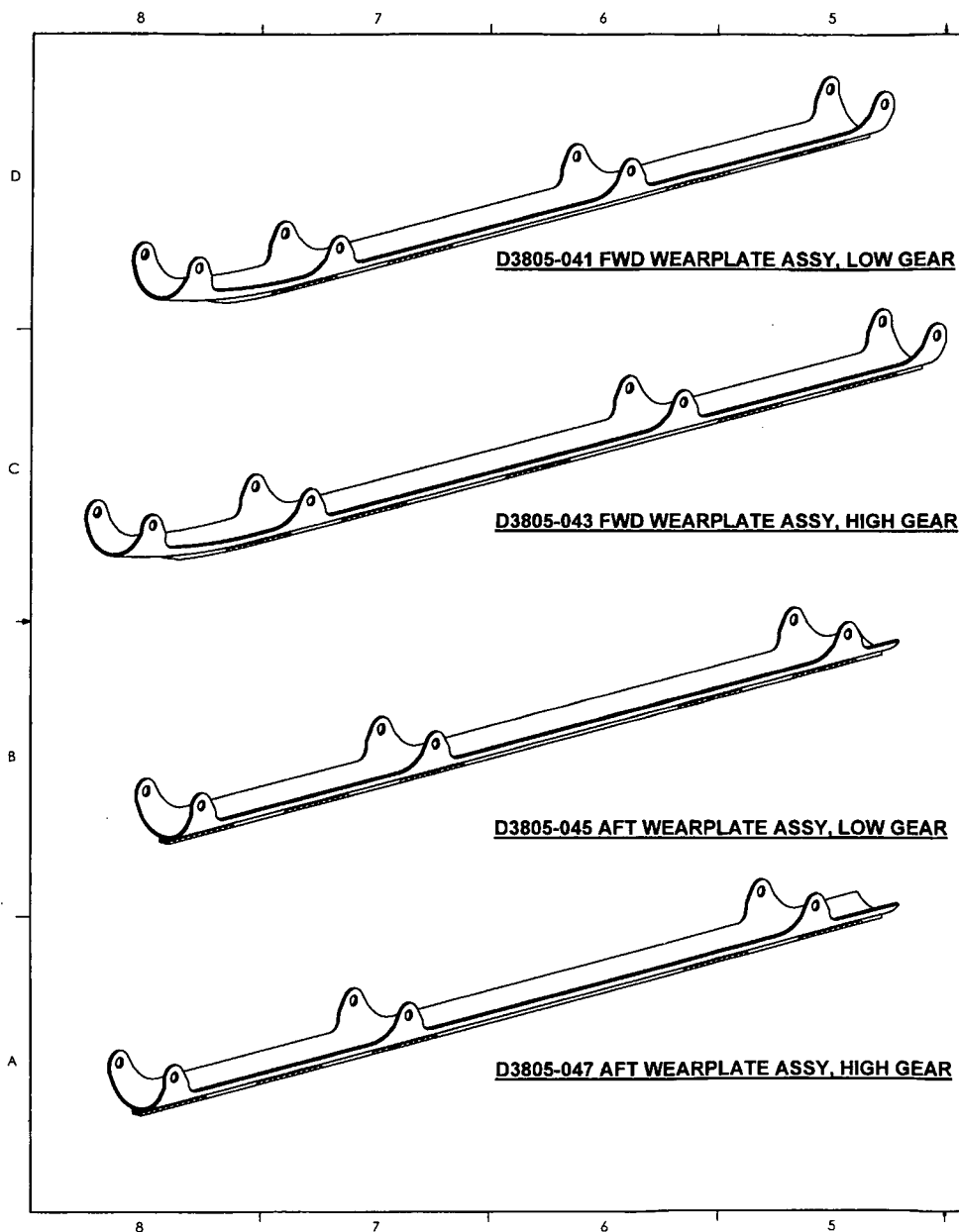
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

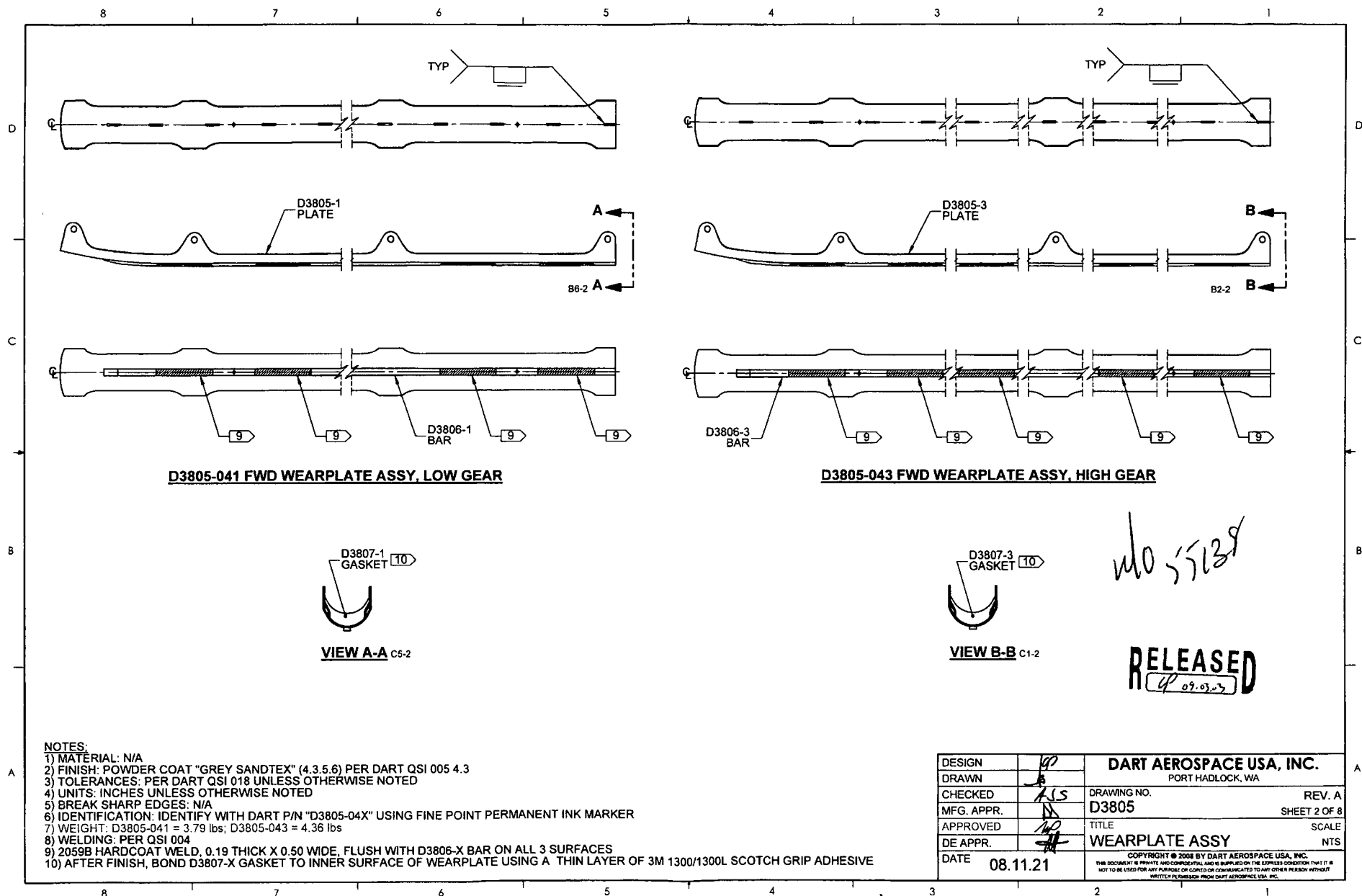


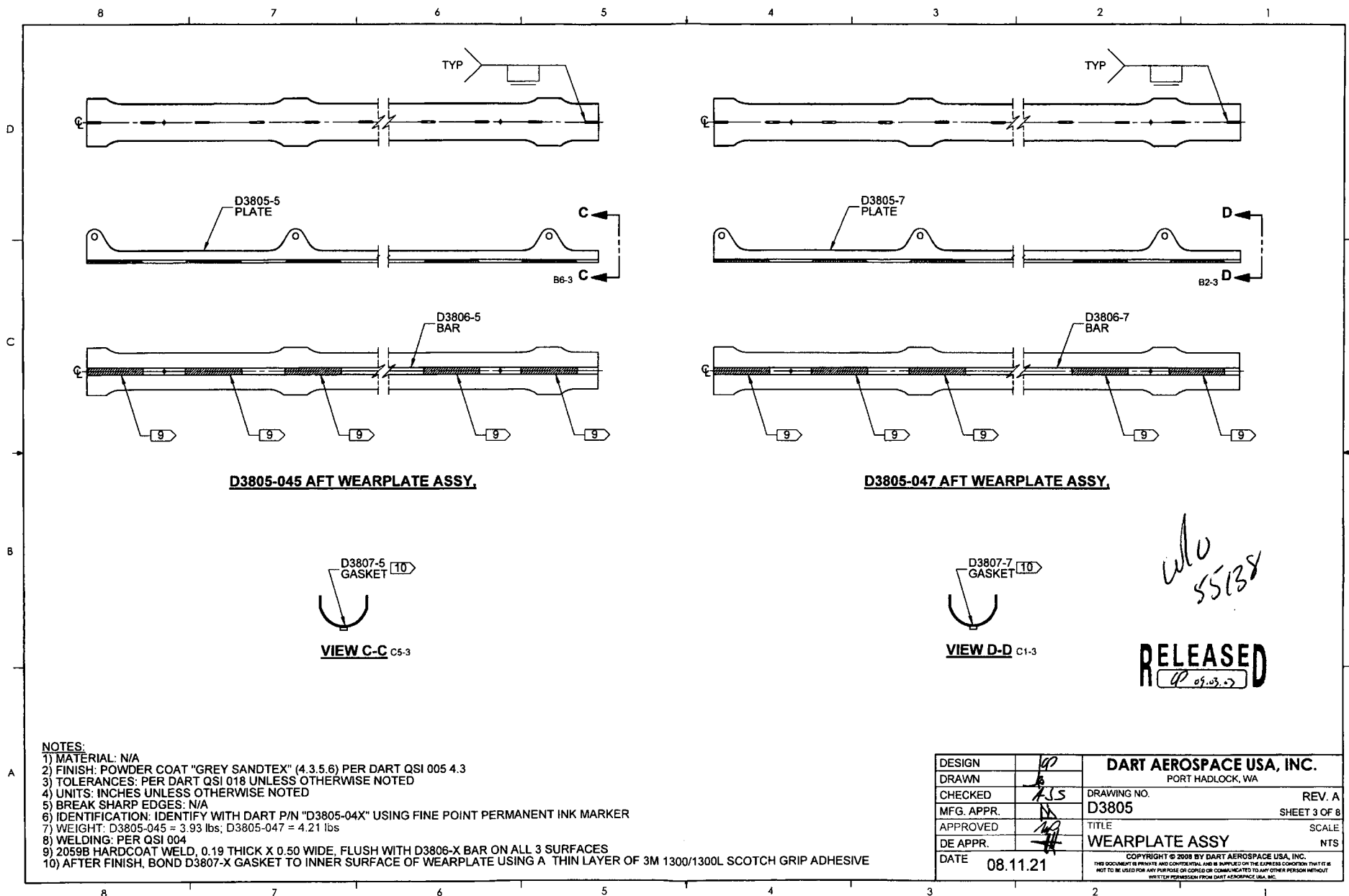
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

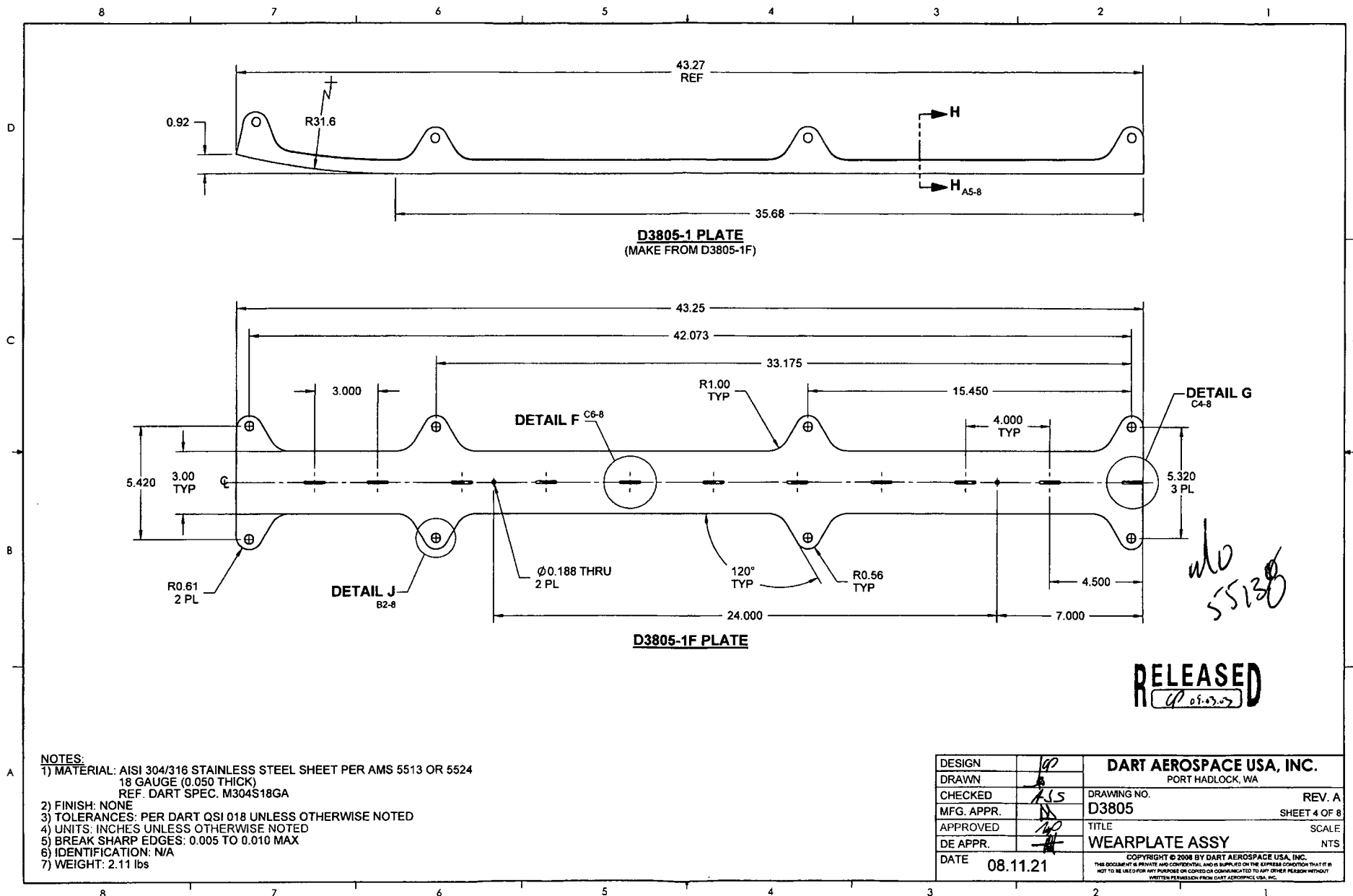
5538

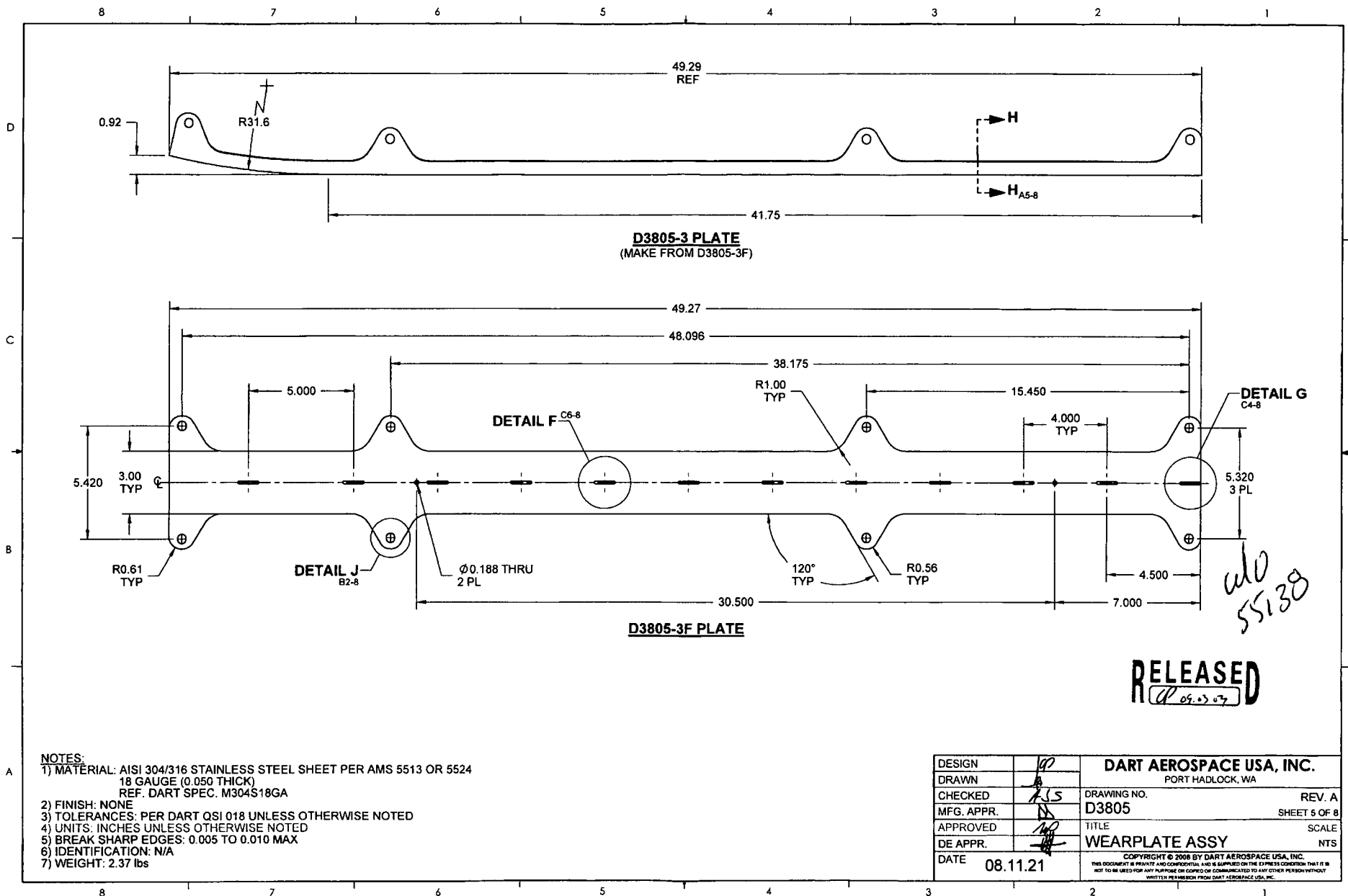
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09.03.03
Per ECU 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
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DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 1 OF 8
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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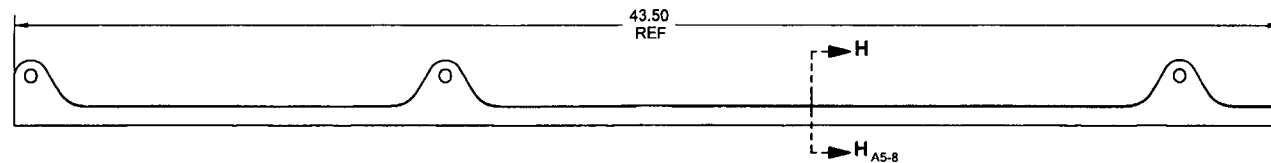




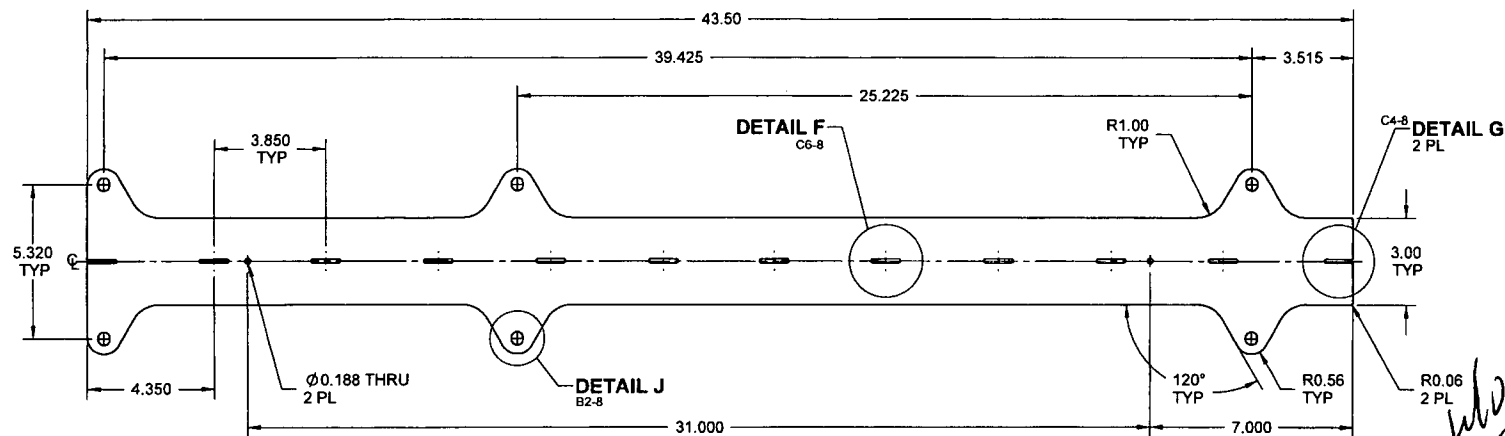
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

DESIGN	140	DART AEROSPACE USA, INC.	
DRAWN	145	PORT HADLOCK, WA	
CHECKED	145	DRAWING NO.	REV. A
MFG. APPR.	145	D3805	SHEET 5 OF 8
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D3805-5 PLATE
(MAKE FROM D3805-5F)



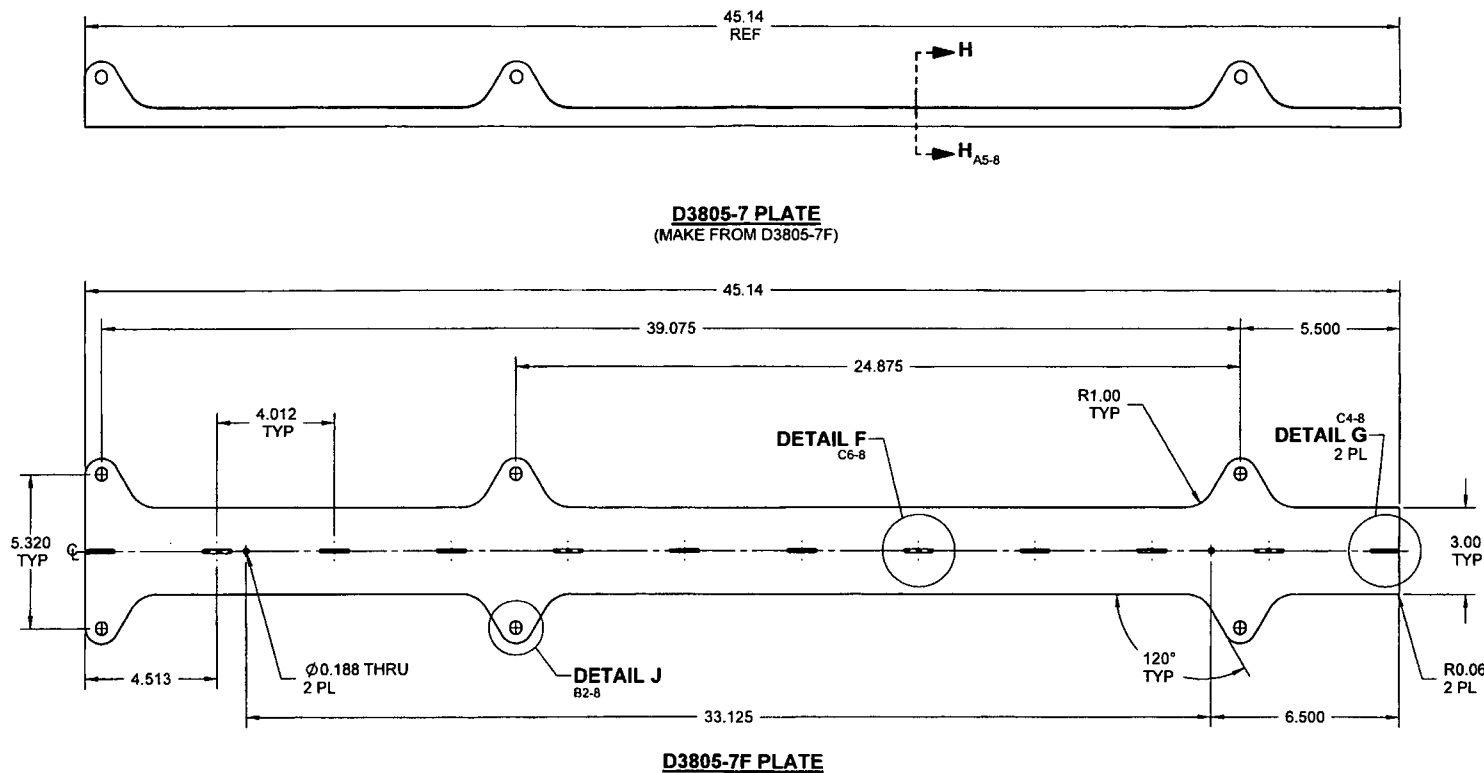
D3805-5F PLATE

RELEASED
40 04-03-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs


DESIGN	40	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 6 OF 8
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DE APPR.	JS	WEARPLATE ASSY	NTS
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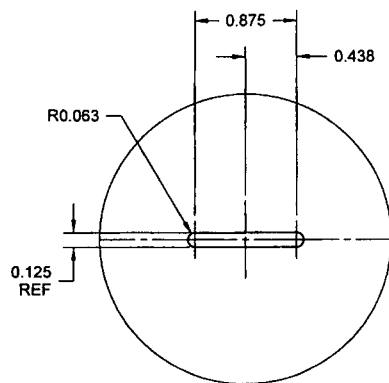


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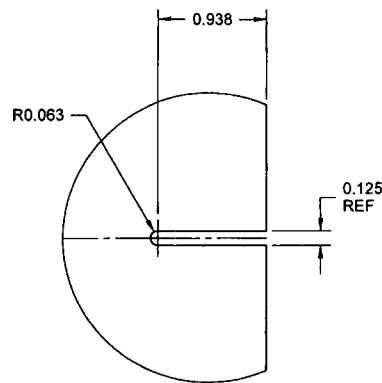
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 18 GAUGE (0.050 THICK)
 REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

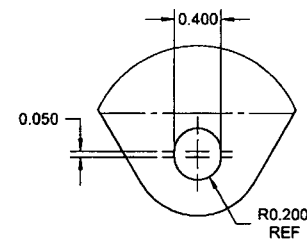
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 7 OF 8
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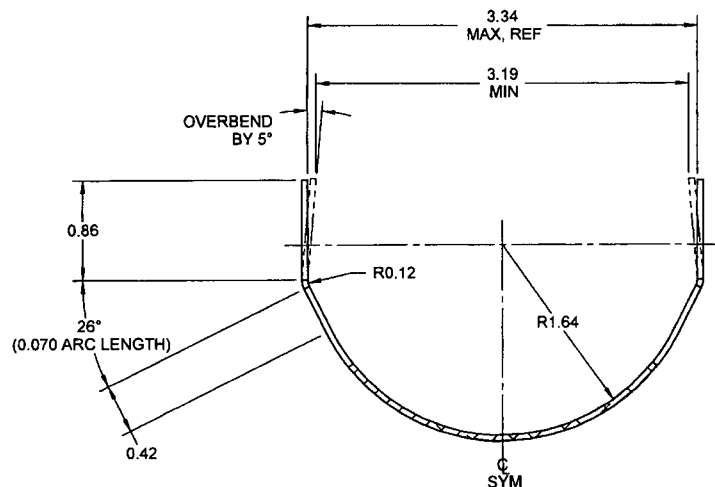
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SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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4709.03.03

DESIGN	197	DART AEROSPACE USA, INC.	
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CHECKED	215	DRAWING NO.	REV. A
MFG. APPR.	197	D3805	SHEET 8 OF 8
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